

Date: Tuesday, 11/29/2005 6:52:08 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW RING
Job Number : 25040	
Estimate Number : 10794	
P.O. Number : N/A	Part Number : D3407041
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>EST REV A 05/10/14 KJ/C</u>	Due Date : 12/20/2005 Qty: 10 Um: Each
Checked & Approved By : <u>See Above</u>	
Comment : Created By Auto Work Order	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34071 Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-1	Stem	<u>B25068</u>

CPL 06.01.05 (10)

## Tools:

2.0 D34075 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-5	Ring	<u>B25046</u>

CPL 06.01.05 (10)

## Tools:

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 &amp; QSI 004

A/R TIG174 ROD Batch: M10774

CPL 06.01.05 (10)

## Tools:

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

M 06/02/06 10

## Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 6:52:09 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 25040

Part Number: D3407041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*Mask Threaded Section\*\*

ml 06 01 09 10

Tools:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/01/09

10

Tools:

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

06/01/09

10

Tools:

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

545 06/01/10 (10)

SP 06/01/10 (10)

Job Completion



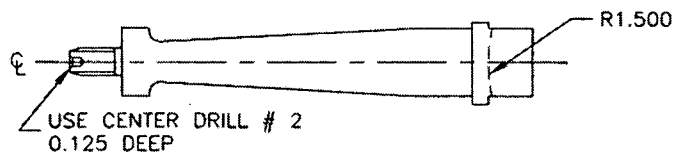
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

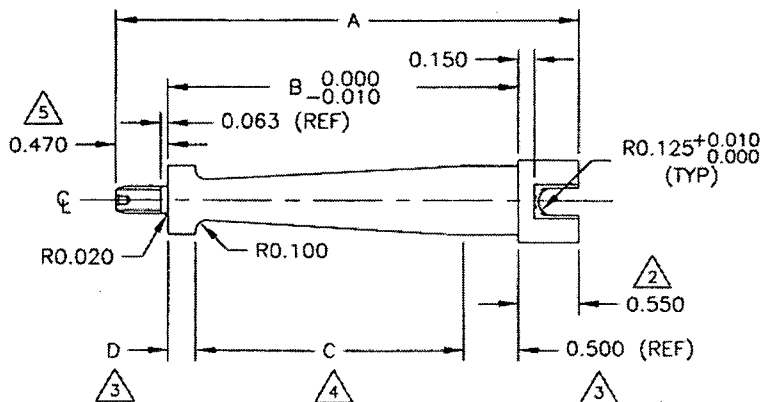
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**RELEASED**

05 09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

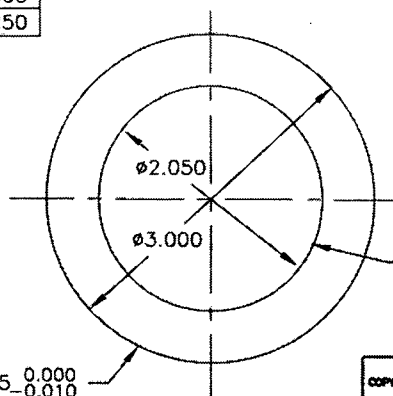
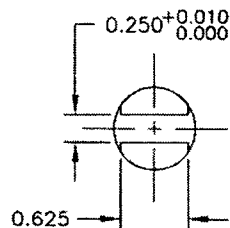
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

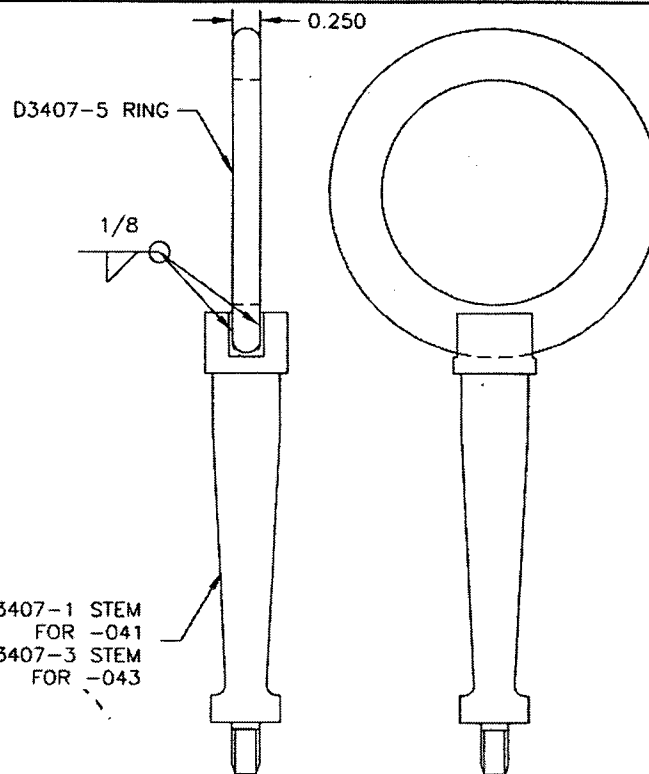
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE USA, INC.
CHECKED	CP	DART AEROSPACE USA, INC.
APPROVED	CP	DART AEROSPACE USA, INC.
DRAWING NO.	D3407	
DATE	05.09.09	
TITLE	TOW RING	

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REV. 0  
SHEET 1 OF 1  
SCALE  
1:1